

Tuesday, July 29, 2014 2:25:56 PM

Page 1

Reference:

Stop *NR2*

Draw Nbr	Revision Nbr	
D3849	D	

0.00

DAS
23
9-89

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3849

Dwg Rev: 1

Prog Rev: 0

2-Deburr if necessary

0.00

DAS
23
9-89

QC

Memo

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC/Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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Work Order ID 122919

Tuesday, July 29, 2014 2:25:56 PM

122919

Page 3

Item ID: D3849-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 7/28/14

Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/29/14

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

Identify as per dwg & Stock Location: **WAD002**

0.00

220

Packaging

Memo

0.00

Packaging

8 **14-08-22** **MAC**

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.00

Quality Control

ML5 **14-08-22****14-8-22**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Training									
Transport									
Unapproved									

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* Picklist Print

Tuesday, July 29, 2014 2:25:56 PM

Page 1

Work Order ID: 122919

122919

Parent Item: D3849-5

D3849-5

Parent Item Name: Plate

Start Date: 7/28/14

Required Date: 7/29/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 12.09.11 AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

100

sf

629.9700

4

~~26~~

**

27.5

DAS

23

9-89

M304S18GA

304/316 .050 Sheet

14-08-12

Location

Loc Qty

Loc Code

MAT019

617.97

117188

3

117766

5

120604

5

122325

3

123155

3

124572

38

M126647

31.55

M128254

90.17

M128435

123.25

M128864

64

M129530

252

129530

MAT020

12

124029

2

M126098

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Equip/Tooling									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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DART AEROSPACE LTD		Work Order: 122919
Description: Wearplate		Part Number: D3849-5
Inspection Dwg: D3849	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.188	✓		✓	JKM 01
Ø0.375	+0.006/-0.001	0.375	✓		✓	
0.125	+/-0.010	0.125	✓		✓	
0.88	+/-0.030	0.88	✓		✓	
0.75	+/-0.030	.75	✓		✓	
3.283	+/-0.010	3.283	✓		✓	
2.433	+/-0.010	2.435	✓		✓	
6.642	+/-0.010	6.642	✓		✓	
7.72	+/-0.030	7.72	✓		✓	
2.45	+/-0.030	2.45	✓		✓	
18.712	+/-0.010	18.712	✓		↑	
36.622	+/-0.010	36.622	✓		T	JKM 07
62.788	+/-0.010	62.788	✓		T	JKM 07
75.261	+/-0.010	75.261	✓		T	JKM 07
7.00	+/-0.030	7.00	✓		✓	
79.76	+/-0.030	79.76	✓		T	JKM 07
0.050	+/-0.010	0.047	✓		✓	JKM 01

DAS

38

9-89

Measured by: <i>an/a</i>	Audited by: <i>38</i>	Preliminary Approval:
Date: 14/18/12	Date: 14/08/18	Date:

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue P/O D3849-045	KJ	
B	12.09.26	Dimensions updated per Dwg Rev D	KJ	

8

7

6

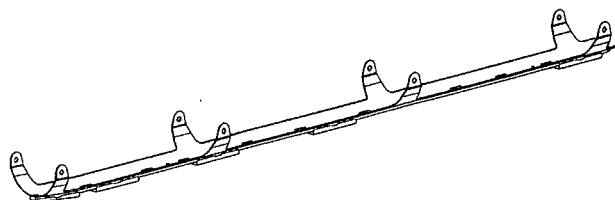
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4

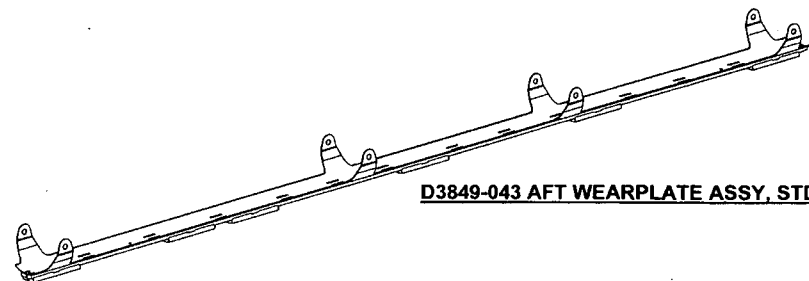
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2

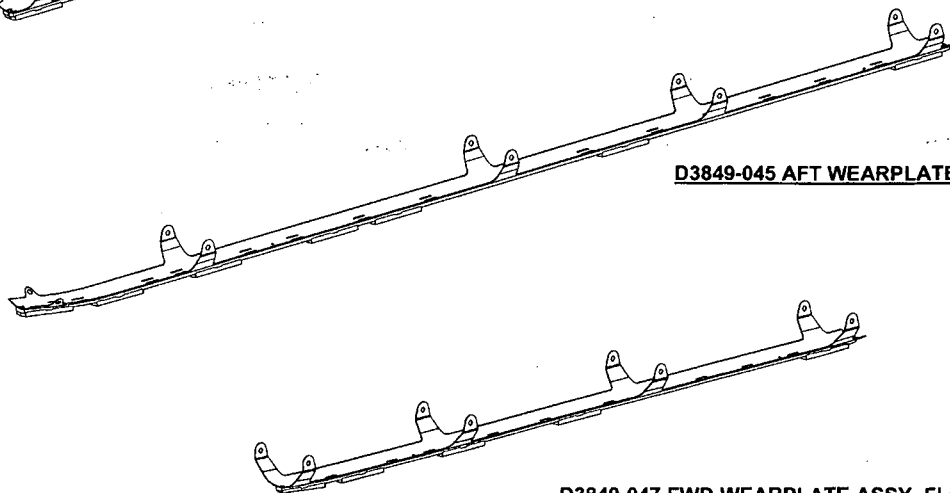
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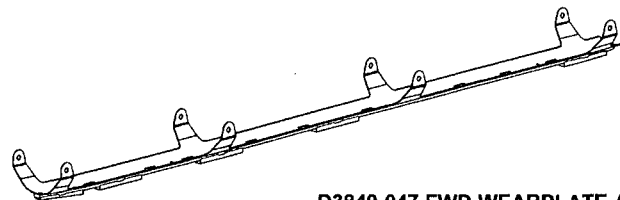
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR

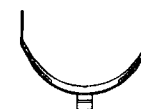
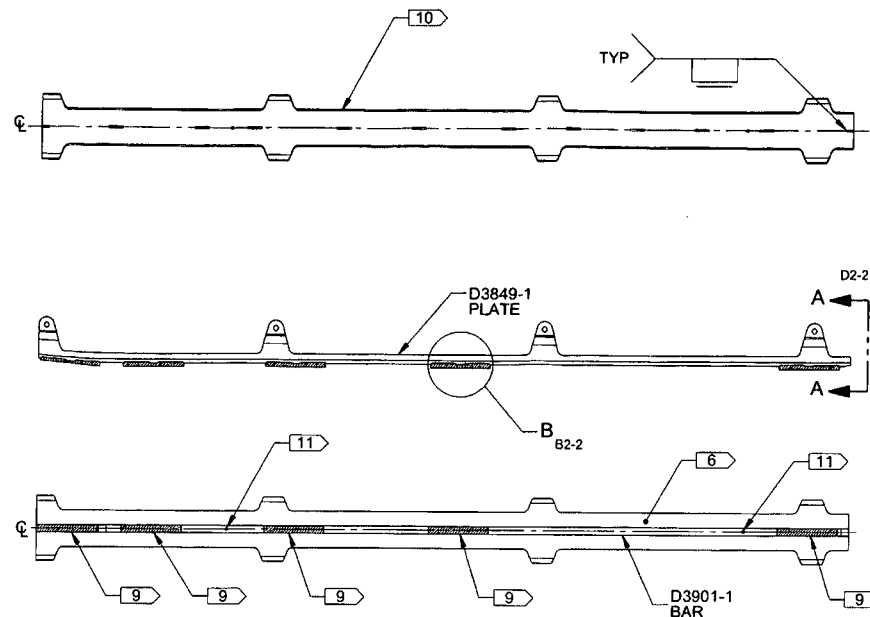
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1			1	D3901-1	BAR
16		2			D3901-3	BAR
17			2		D3901-5	BAR
21	A/R	A/R	A/R	A/R	2059B	HARDCOAT
22	A/R	A/R	A/R	A/R	4714	PLUS ONE ROCKGUARD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

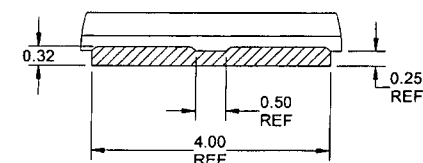
NO. 122919
1/30/14 um

RELEASED
2012-09-04

D	REVISED FLAT PATTERN - CHANGED SLOT LOCATIONS TO MATCH D3901-1/3/5 BARS (ZN B6-6, B3-6, B6-7, C2-7, B6-8, B2-8, B7-9, B2-9).	DC	12.08.23
C	REVISED FLAT PATTERN - CHANGE SLOT LOCATIONS. ADDED DOUBLE SLOTS AND D3901-3/5 BARS ON -043/-045. UPDATED DETAIL VIEWS. CHANGED WELD DETAILS (ZN B2-2). REMOVED D3848-1/3/5/7 GASKETS, ADD ROCKGUARD COATING. REMOVE FINISH.	DC	12.08.21
B	REVISED FLAT PATTERN. Ø0.375 WAS SLOT HOLE ON D3849-1/1/3/5/7 (ZN A4-5, B4-7, B4-8, C2-10, B2-10). ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/7/7 (ZN C4-9, A4-9). ADD SECTION K-K (ZN C5-10). 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10). ADD 0.25 & 0.88 (ZN D4-10, D3-10). ADD 0.88 & 0.44 (ZN C3-10 & B3-10). ADD FLAG NOTE (ZN A5-2, C6-2, C3-2, A6-3, C6-3, C3-3, A6-4, C6-4, C2-4). B6, B7 WAS B7.36 (ZN B4-7).	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D3849	SHEET 1 OF 10
APPROVED	140	TITLE	SCALE
DE APPR.	140	WEARPLATE ASSY	NTS
DATE	12.08.23	<small> COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	



SECTION A-A
C3-2



DETAIL B
C5-2

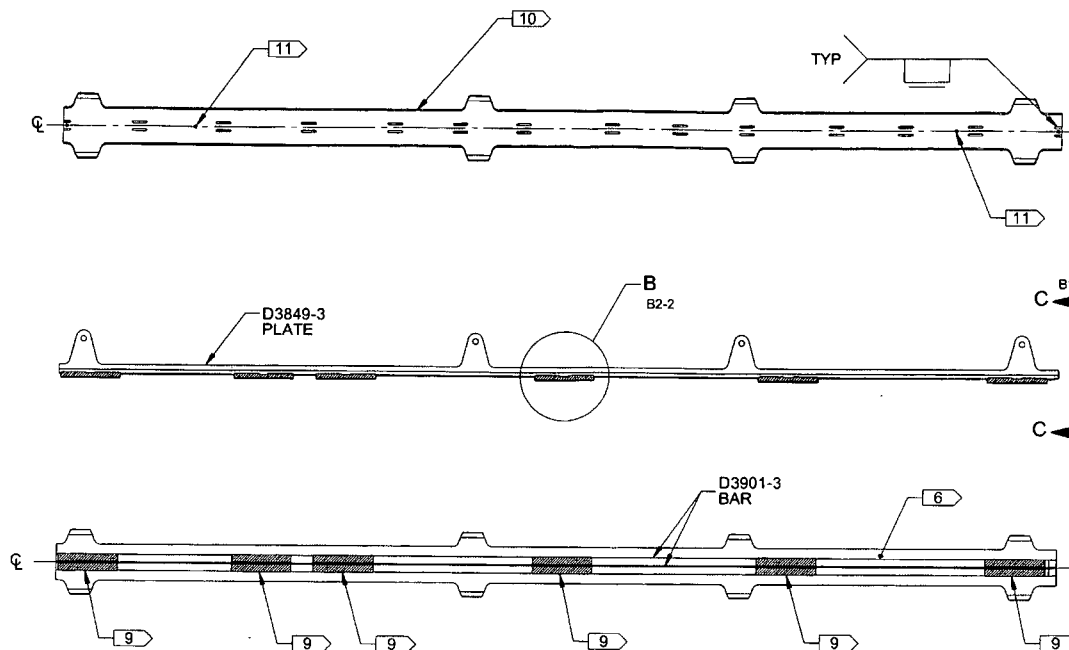
D3849-041 FWD WEARPLATE ASSY, STD/FLOAT GEAR

NOTES:

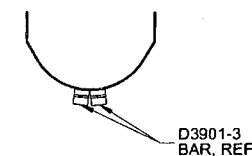
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-041 = 4.58 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL \varnothing 0.188 HOLES FROM D3849-1 PLATE TO D3901-1 BAR

RELEASED
2012-09-04
mp

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO.	REV. D
MFG. APPR.	BC	D3849	SHEET 2 OF 10
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	WEARPLATE ASSY	NTS
DATE	12:08:23	<small>COPYRIGHT © 2002 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D3849-043 AFT WEARPLATE ASSY, STD GEAR



SECTION C-C

C3-3

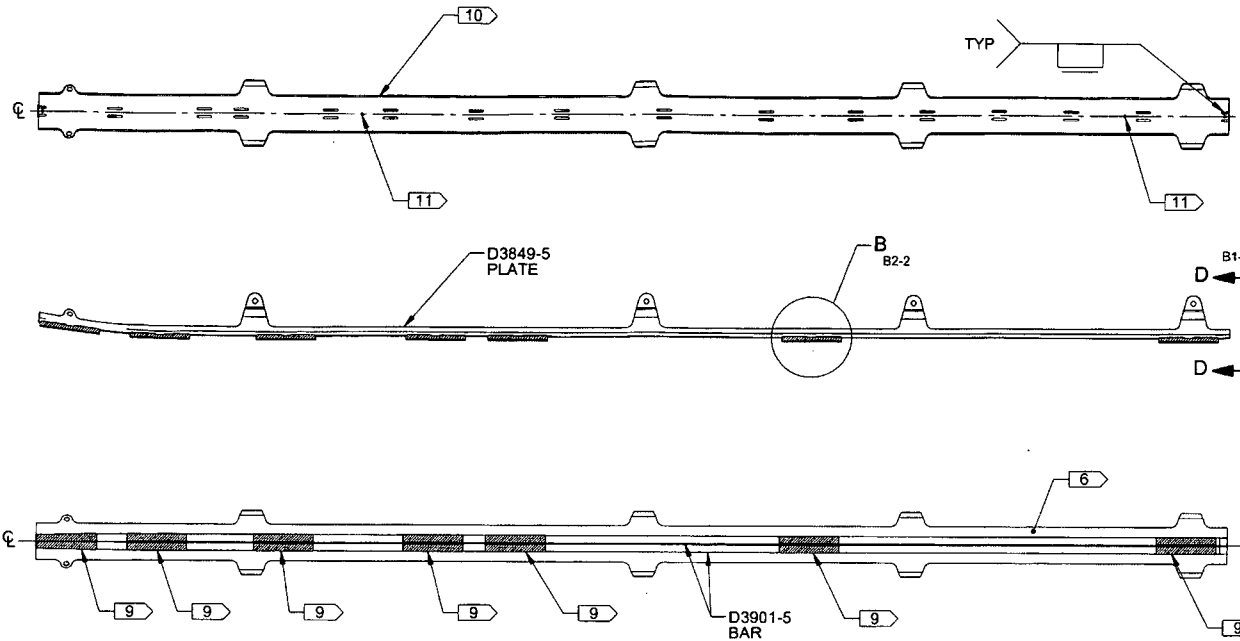
RELEASED
2012-09-04

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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-043 = 7.66 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BARS ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL \varnothing 0.188 HOLES FROM D3849-3 PLATE TO D3901-3 BARS

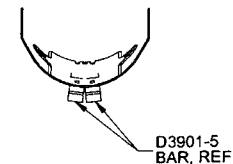
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D3849	SHEET 3 OF 10
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR

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2012-09-04



SECTION D-D

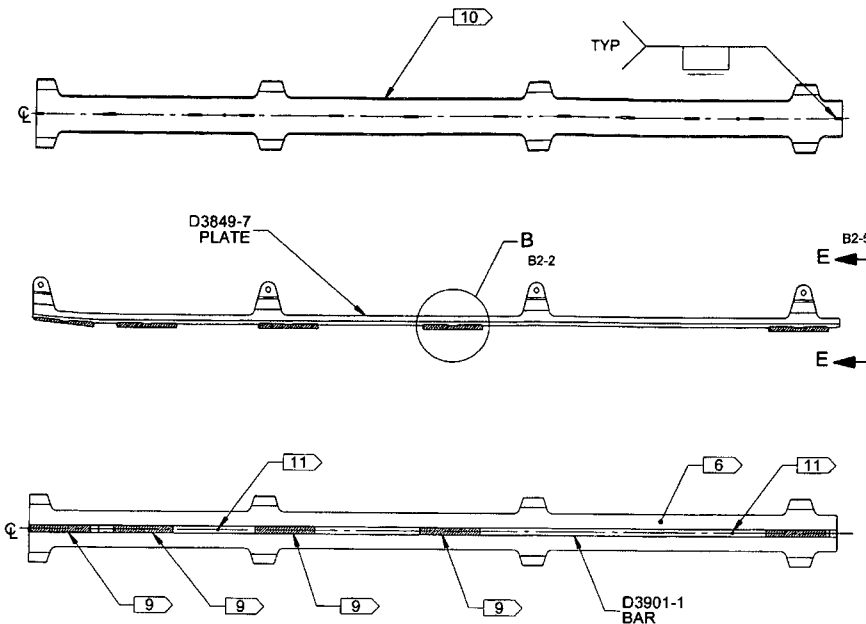
C2-4

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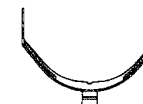
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-045 = 8.93 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BARS ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL $\phi 0.188$ HOLES FROM D3849-5 PLATE TO D3901-5 BARS

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8 7 6 5 4 3 2 1



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR



SECTION E-E

C3-5

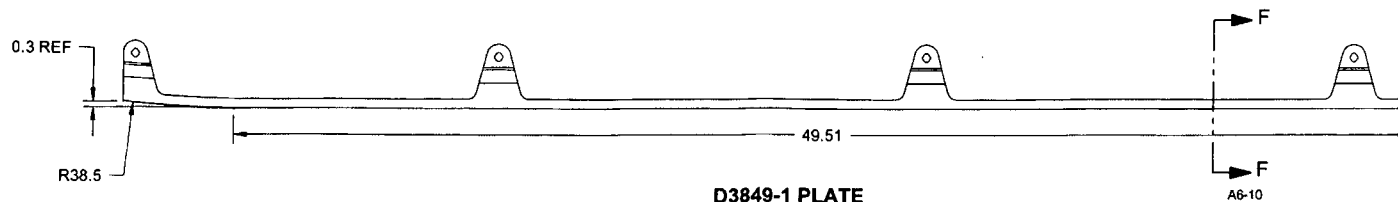
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2012-09-04

NOTES:

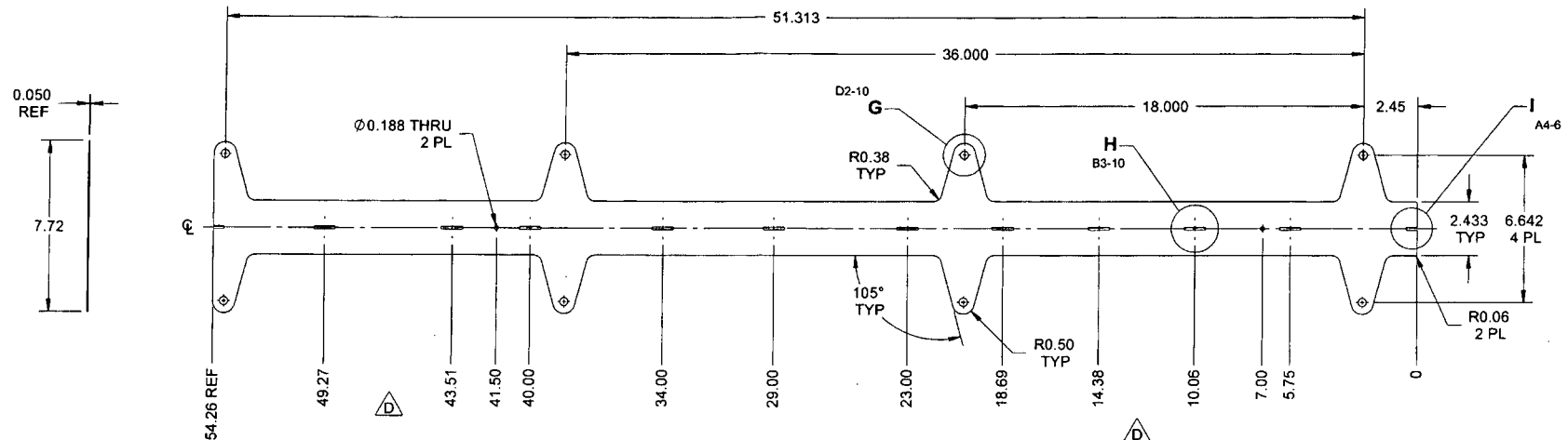
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-047 = 4.60 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL, $\phi 0.188$ HOLES FROM D3849-7 PLATE TO D3901-1 BAR

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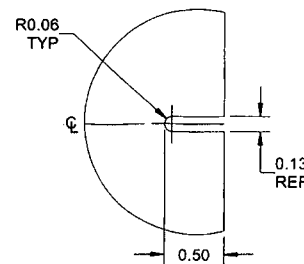
8 7 6 5 4 3 2 1



D3849-1 PLATE
(MAKE FROM D3849-1F)



D3849-1F FLAT PATTERN



DETAIL I

C2-6
B2-9

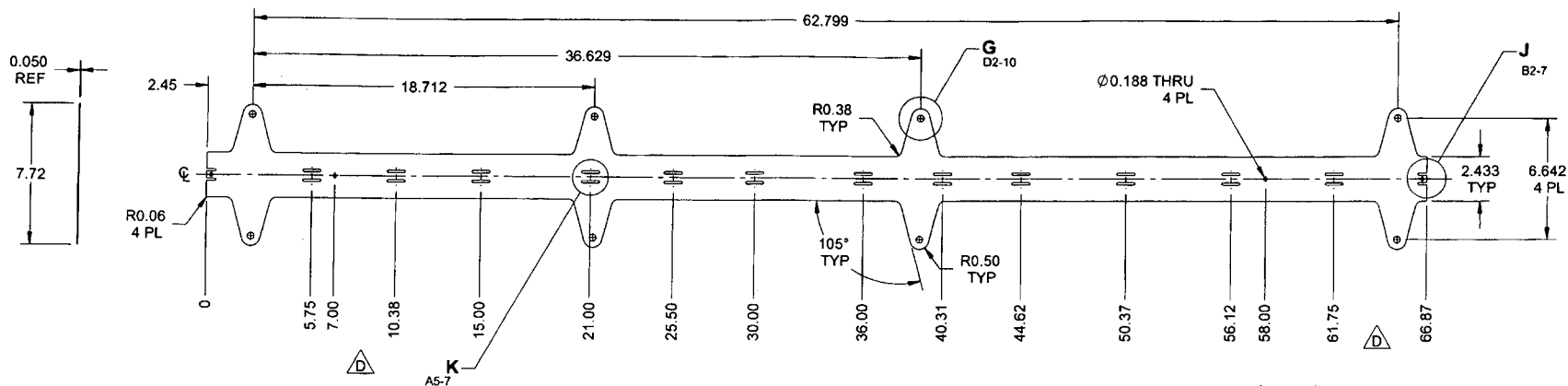
RELEASE
2012-09-04

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.30 lbs

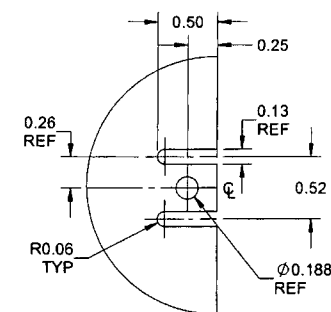
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8 7 6 5 4 3 2 1

D3849-3 PLATE
(MAKE FROM D3849-3F)

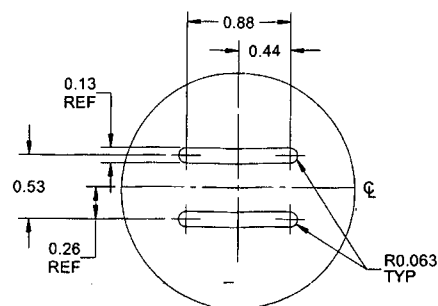


D3849-3F FLAT PATTERN



DETAIL J

C2-7
B2-8



DETAIL K

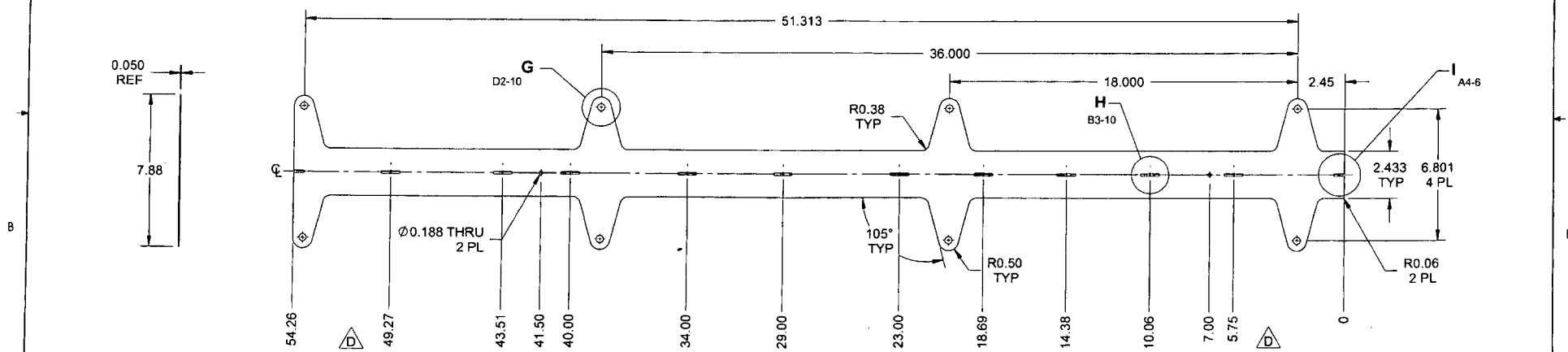
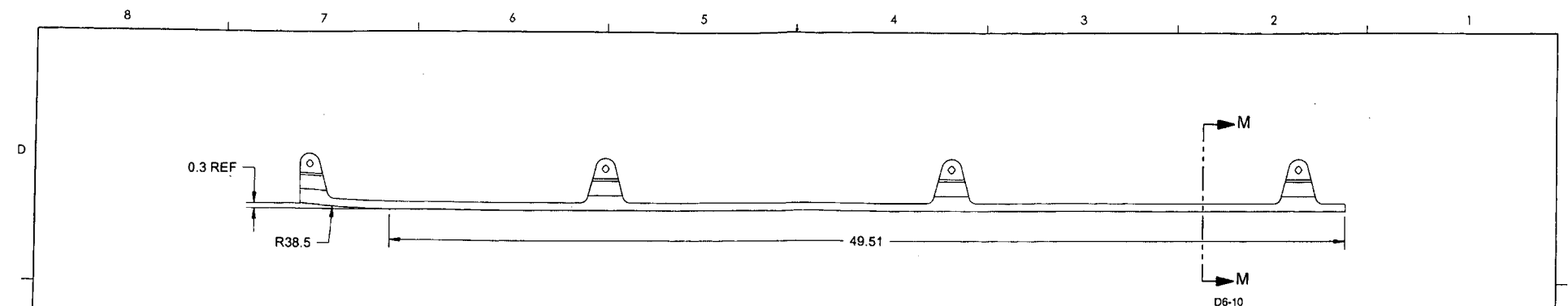
C5-7
B5-8

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.74 lbs

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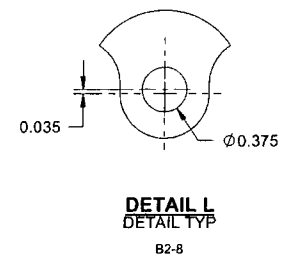
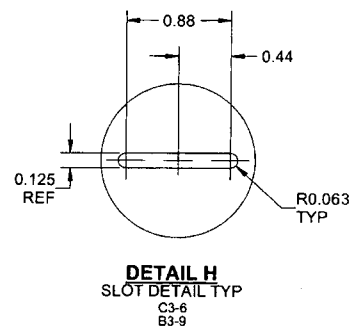
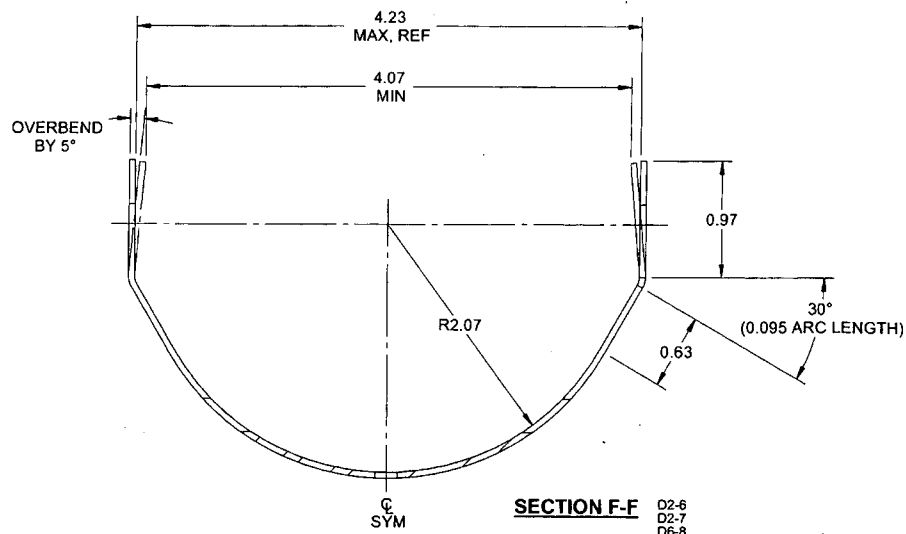
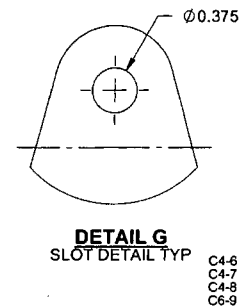
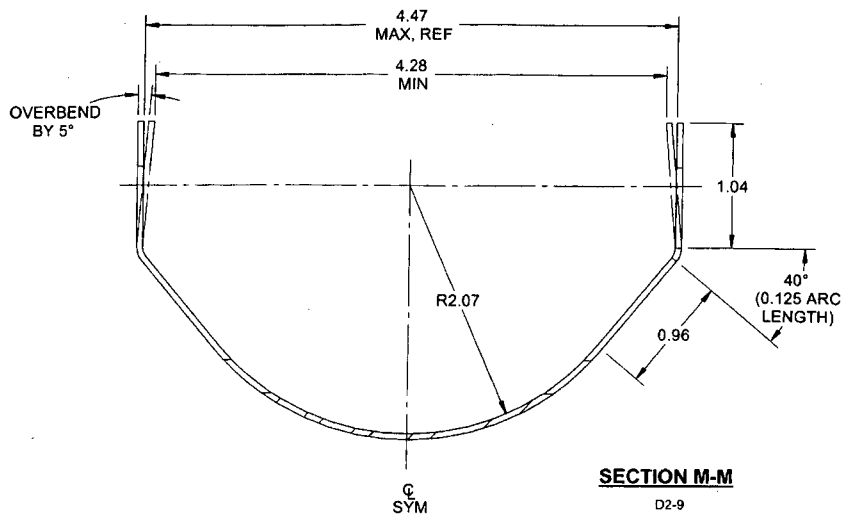
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 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.32 lbs

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